

303 1.00



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200
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D4764-1

Job Sheet 200814



Part No: D4764-1

Job Qty: 100 pcs

Part Name: Bushing



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/18/19

Job Tracking No:

Due Date: 10/7/19

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG REV B IPP REV:A NEW ISSUE 13-03-27 JLM VERIFIED BY:DD IPP REV:B 13.11.14 AS PER DWG
REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Hardinge - 1	100 pcs	10/7/19	10/7/19	0.50	10.74	Hardinge - 1	BM 18-10-22
120	QC 8	100 pcs	10/7/19	10/7/19	0.00	0.00	QC 8 - 12	5-89
							QC 8 - 14	
							QC 8 - 17	
							QC 8 - 20	
							QC 8 - 25	
							QC 8 - 3	
							QC 8 - 32	
							QC 8 - 33	
							QC 8 - 35	
							QC 8 - 39	
							QC 8 - 4	
							QC 8 - 44	
							QC 8 - 45	
							QC 8 - 49	
							QC 8 - 58	
							QC 8 - 8	
							QC 8 - 9	
							QC 8 - 68	
							QC 8 - 67	
							QC 8 - 1 (A)	
							QC 8 - 47	
							QC 8 - 40	DAS 52 17/10/23
							QC 8 - 52	9-89
							QC 8 - 23	
							QC 8 - 57	



Container No: S225309



Part: D4764-1

Job No: 200814

Serial No/Batch: S225309

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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Date: 10/22/19

				QC 8 - 76	
130 Packaging 3-1 - Stock - B4B	100 pcs ✓	10/7/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B ✓	ST 114
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	100 pcs ✓	10/7/19	0.00 0.00	QC 21 - SA - 21 ✓	ST 114
				QC 21 - SA - 70	DAS
				QC 21 - SA - 53	21 OCT 24 2019

Part Op 100 - Hardinge - 1-TURN AS PER FOLIO FB179 & DWG ,
 Descriptions: 120 - QC8- Inspect parts - second check
 130 - Identify as per dwg & Stock Location: _____
 140 - QC21- Final Inspection - Work Order Release

9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R1.000	303 Round Bar 1.00	6.1250 ft (.06125 ea)	100-Hardinge - 1	S22 1910

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	M303R1.000	6	30	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.990Inches + 0.010 - 0.001	1.000 0.989	0.991 Diameter	
2	Bushing	0.261Inches + 0.006 - 0.001	0.267 0.260	0.261 Diameter	
3	Bushing	0.060Inches $\pm$ 0.010	0.070 0.050	0.064	
4	Bushing	0.750Inches $\pm$ 0.010	0.760 0.740	0.753	
5	Bushing	0.621Inches + 0.008 - 0.001	0.629 0.620	0.622 Diameter	
6	Bushing	0.075Inches $\pm$ 0.010	0.085 0.065	0.072	
7	Bushing	20.000Degrees $\pm$ 0.500	20.500 19.500	20° Angle	
8	Bushing	0.050Inches $\pm$ 0.010	0.060 0.040	0.058	
9	Bushing	45.000Degrees $\pm$ 0.500	45.500 44.500	45° Angle	

Plex 9/18/19 9:03 AM Dart.Renwick.Jennifer



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QS1042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced ☐
Bending ☐
Crushing ☐
Cracks ☐
Grimp/Kink/Ripple/Wave/Twist ☐
Marks/Chatter ☐
Mislabeled ☐
Contamination ☐
Misaligned/off center ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Incomplete/Unclear Instructions ☐
Drill Holes ☐
Fit/Function ☐

Power Loss/Surge ☐
Folio/Program ☐
Grain Direction ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set/Set-up ☐

Positioned Wrong ☐
Outside Tolerance ☐
Drawing ☐
Finish ☐
Part Lost/Missing ☐
Misread ☐

Other/Details: _____